

Claims

1. A threaded joint for steel pipes comprising a pin and a box each having a contact surface including a threaded portion and an unthreaded contact portion,
5 characterized in that the contact surface of at least one of the pin and the box is coated with a metallic undercoating layer and a lubricating coating layer thereon, the undercoating layer has a porosity of 5 - 80% and a thickness of 1 - 30 μ m, the lubricating coating layer is comprised of a solid lubricating coating or a liquid lubricating coating, the latter containing substantially no heavy metal powders, and the
10 total thickness of the undercoating layer and the lubricating coating layer is at most 100 μ m.

2. A threaded joint for steel pipes as claimed in claim 1 wherein the undercoating layer has a hardness of 50 - 250 Hv.

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3. A threaded joint for steel pipes as claimed in claim 1 wherein the undercoating layer is formed by electroplating, blast coating, or flame spraying.

4. A threaded joint for steel pipes as claimed in claim 1 wherein the
20 undercoating layer is formed of a metal selected from Zn, Cu, Ni, Sn, Cr, Al, Co, precious metals, and alloys thereof.

5. A threaded joint for steel pipes as claimed in claim 1 wherein the lubricating coating layer is a liquid lubricating coating which consists essentially of a basic metal
25 salt of an organic acid or which contains a basic metal salt of an organic acid.

6. A threaded joint for steel pipes as claimed in claim 1 wherein the lubricating coating layer comprises a solid lubricant and a binder which can form an organic or inorganic coating.

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7. A threaded joint for steel pipes as claimed in claim 2 wherein the undercoating layer is formed by electroplating, blast coating, or flame spraying.

8. A threaded joint for steel pipes as claimed in claim 2 wherein the undercoating layer is formed of a metal selected from Zn, Cu, Ni, Sn, Cr, Al, Co, precious metals, and alloys thereof.

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9. A threaded joint for steel pipes as claimed in claim 2 wherein the lubricating coating layer is a liquid lubricating coating which consists essentially of a basic metal salt of an organic acid or which contains a basic metal salt of an organic acid.

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10. A threaded joint for steel pipes as claimed in claim 2 wherein the lubricating coating layer comprises a solid lubricant and a binder which can form an organic or inorganic coating.

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